

**Work Order ID 64030**

November 23, 2010 10:07:46 AM



Page 1

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Item Name: Tank Aft End

Stop



Start Date: 11/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 10/10/23

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4055	A

100 Waterjet Memo 0.00



Waterjet

FLOW CNC Waterjet

6061 .063

Memo

Cut as per dwg D4055

Prog rev: ADwg rev: AB10-10-93

110 QC2- Inspect parts off machine FAI/FAIB Memo 0.00



QC

Quality Control

B10-10-9

120 QC8- Inspect parts - second check Memo 0.00



QC

Quality Control

10 10 09 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Bend as per dwg

0.00

80

10/12/09

③



Brake NC

Memo

Brake NC

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

Quality Control

3

10/12/09

150

Identify as per dwg & Stock Location: 1014

0.00



Packaging

Memo

Packaging

10/12/17 3 8

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Start Date: 11/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/12/2011

WRF

10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

November 23, 2010 10:07:45 AM

Page 1

Work Order ID: 64030



Parent Item: D4055-3



Parent Item Name: Tank Aft End

Start Date: 11/23/10

Required Date: 11/30/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM  
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	41.2340	1.5143	4.782			23 10-12 -9

6061-T6 .063 Sheet



Location	Loc Qty	Loc Code
MAT21	41.234	
113608	41.234	

116308

116308

(3)

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DART AEROSPACE LTD	Work Order:	64030
Description: TANK ART END	Part Number:	D4055-3
Inspection Dwg: D4055-3, Rev: A		Page 1 of 1

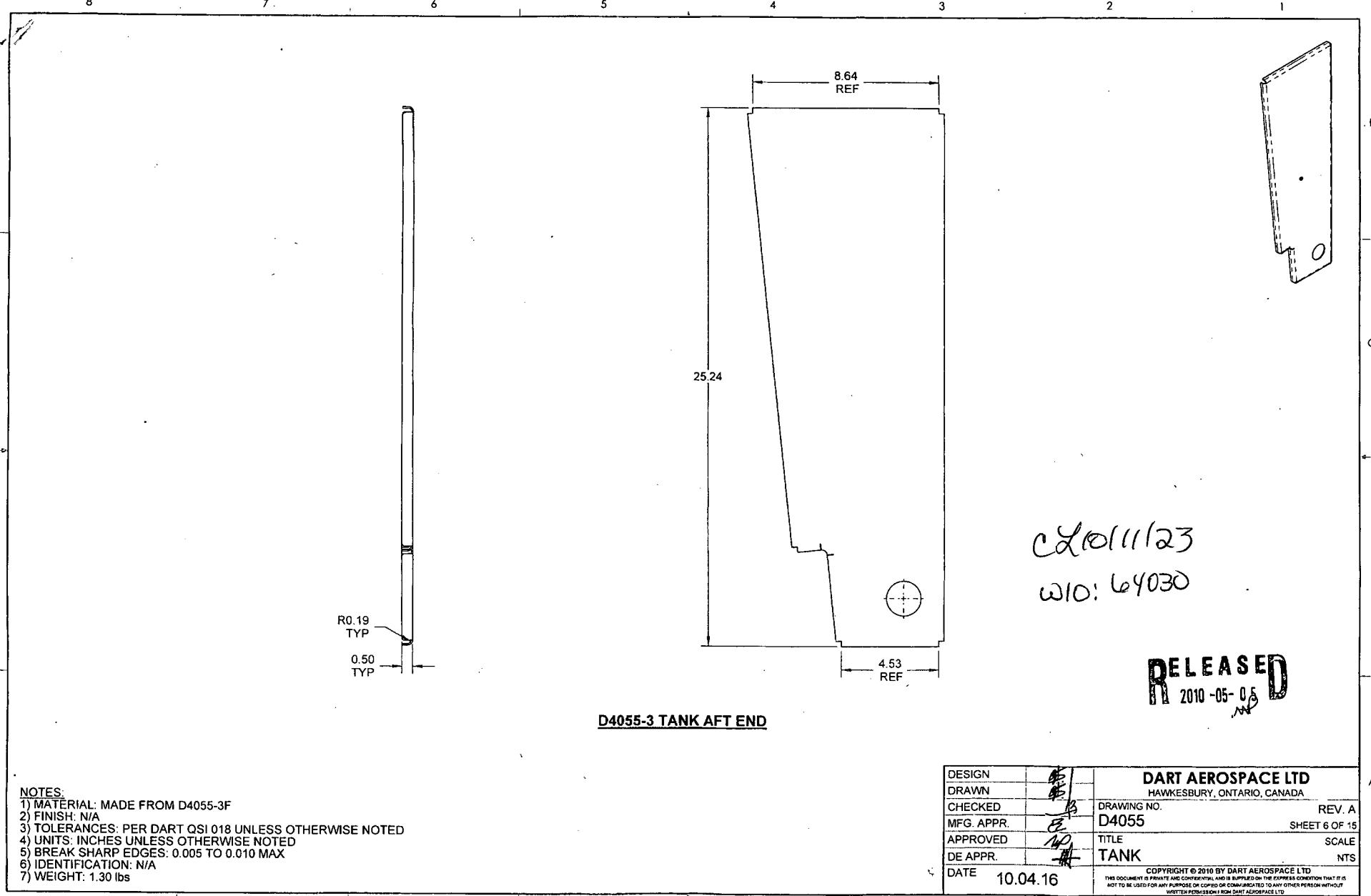
### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.42	+/- .030	BEND			✓	
.59	+/- .030	.597	✓		✓ PB02	
9.23	+/- .030	9.221	✓		✓ PRC/PB02	
9.82	+/- .030	9.820	✓		✓ PRO/PB02	
.59	+/- .030	.600	✓		✓ PRO PB02	
.65	+/- .030	.651	✓		✓	
23.34	+/- .030	23.34	✓		T PB01	
25.34	+/- .030	25.34	✓		T	
25.51	+/- .030	BEND				
25.93	+/- .030	25.93	✓		T	
2.22	+/- .030	2.223	✓		✓	
5.13	+/- .030	5.134	✓		✓	
5.72	+/- .030	5.710	✓		✓	
6.05	+/- .030	6.049	✓		✓	
6.12	+/- .030	6.130	✓		✓	
7.11	+/- .030	7.111	✓		✓	
7.17	+/- .030	7.164	✓		✓	
7.76	+/- .030	7.755	✓		✓	
20.96	+/- .030	20.96	✓		T	
21.02	+/- .030	21.02	✓		T	
21.55	+/- .030	21.55	✓		T	
25.34	+/- .030	25.34	✓		T	
25.40	+/- .030	25.40	✓		T	
.063	+/- .010	.061	✗		✓	

Measured by:	KB	Audited by:	M. M.	Prototype Approval:	
Date:	10-12-09	Date:	10-12-09	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**NOTES:**  
1) MATERIAL: MADE FROM D4055-3F  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018  
4) UNITS: INCHES UNLESS OTHERWISE  
5) BREAK SHARP EDGES: 0.005 TO 0.  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.30 lbs

R0.19  
TYP

D4055-3 TANK AFT END

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. A	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.	
APPROVED	<i>[Signature]</i>	D4055 SHEET 6 OF 15	
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE	10.04.16	TANK	NTS

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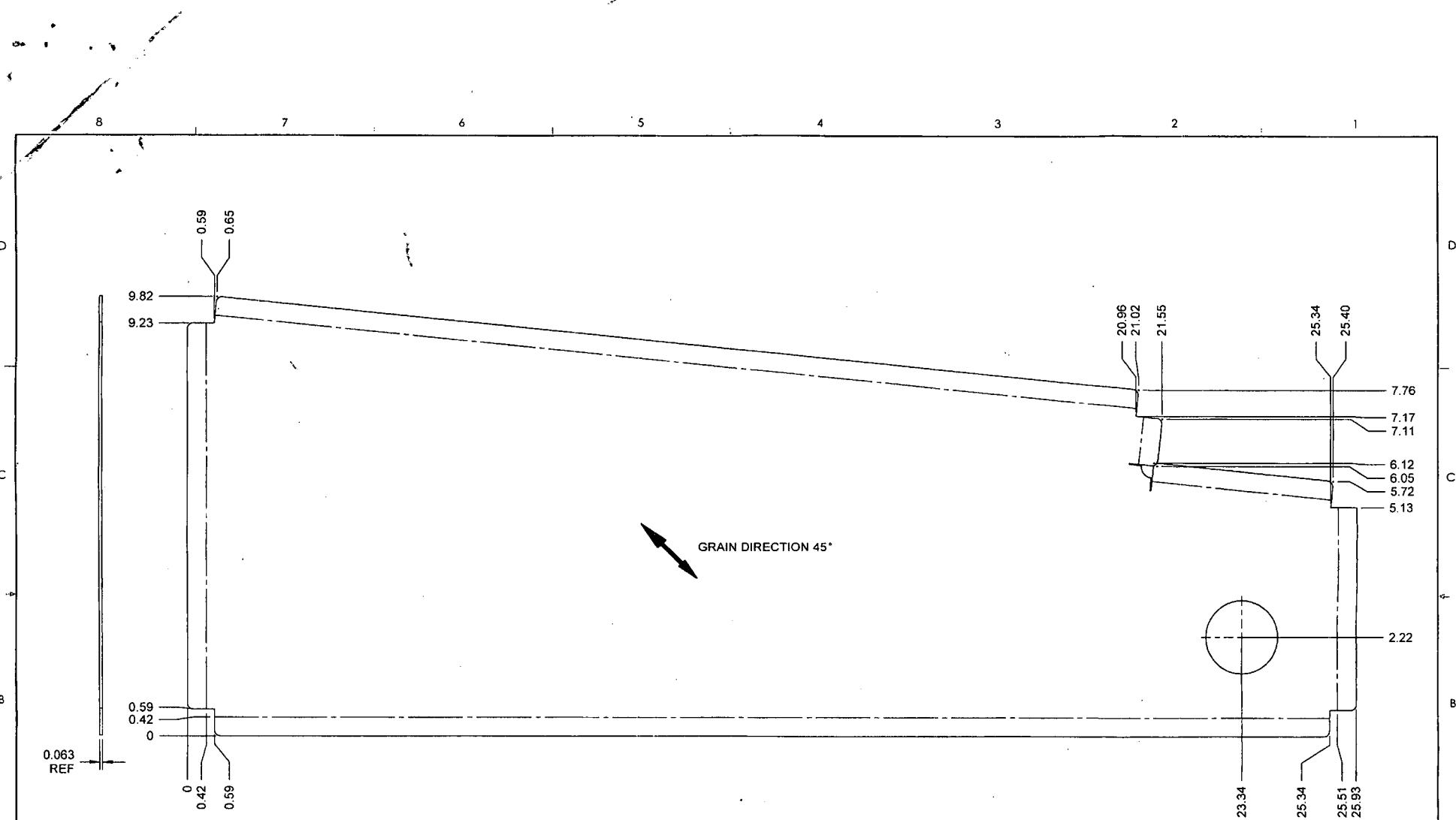
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D4055-3F FLAT PATTERN

A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D4055
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 7 OF 15
DATE 10.04.16		SCALE
		NTS
TANK		

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RELEASED  
R 2010-05-01  
*[Handwritten signatures]*

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